Dart Aerospace Ltd.

Wednesday, 6/27/2007 1:09:05 PM
Kim Johnston

SPLIT - 2

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 33222		
Estimate Number	: 11086		
P.O. Number	: N/A	Part Number	: D31761
This Issue	: 6/27/2007 S.O. No. : N/A	Drawing Number	: D3176 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 25028	Material	: N/A
Written By	:	Due Date	: 7/20/2007 Qty: 6 Unit: Each
Checked & Approved By	: JM 07.06.28		
Comment	: Est Rev.B Removed -3 05-11-29 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
10	M303R1000	303 Round Bar 1.0"

Comment: Qty.: 0.3255 f(s)/Unit Total : 1.3020 f(s)
Material: AISI 303 SS 1.00 round bar
Ref: Dart Spec: M303R1.000)
Batch: M18429 DF / 27/07/11

20	HARDINGE	HARDINGE CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA286 & DWG D3176

2-Deburr DF / 27/07/11 DP 27/7/12 6

30	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE DP 27/7/12 6 DF / 27/07/11

40	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE

1- Mill flats as per dwg D3176 BG 02.07.22

2- Deburr DP 27/7/12 6 (5) PTO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: RL Date: 07/07/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.07.22	4	Undercut on flange. Part moved during machining (1pc)	QS1042	Lighter cuts taken (new method) Scrap 1pc	BG 07.07.22	07/07/23	QS1042	07/07/23

NOTE: Date & initial all entries

Wednesday, 6/27/2007 1:06:25 PM
Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 33222

Part Number: D31761

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC7	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	~~DP 7/07/22 (5)~~ BC 07/07/22 (5)
6.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	ark 07/07/22 (5)
7.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____	CP 07/07/23 (5)
8.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	(5) DD 07/07/23

Job Completion

4 07.07.23

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33222
Description: Bushing	Part Number:	D3176-1
Inspection Dwg: D3176 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.990	+/-0.010	.990	✓			
Ø0.472	+0.010/-0.000	.4755	✓			
3.716	+/-0.010	3.713	✓			
0.130	+/-0.010	.136	✓			
0.277	+/-0.010	.280	✓			
0.550	+/-0.010	.5525	✓			
0.839	+/-0.010	.839	✓			
0.745	+0.005/-0.000	.745	✓			
0.625	+/-0.010	.6725	✓			
5/8-UNF18-3B	N/A	N/A	✓			
0.865	±0.010	0.865	✓			

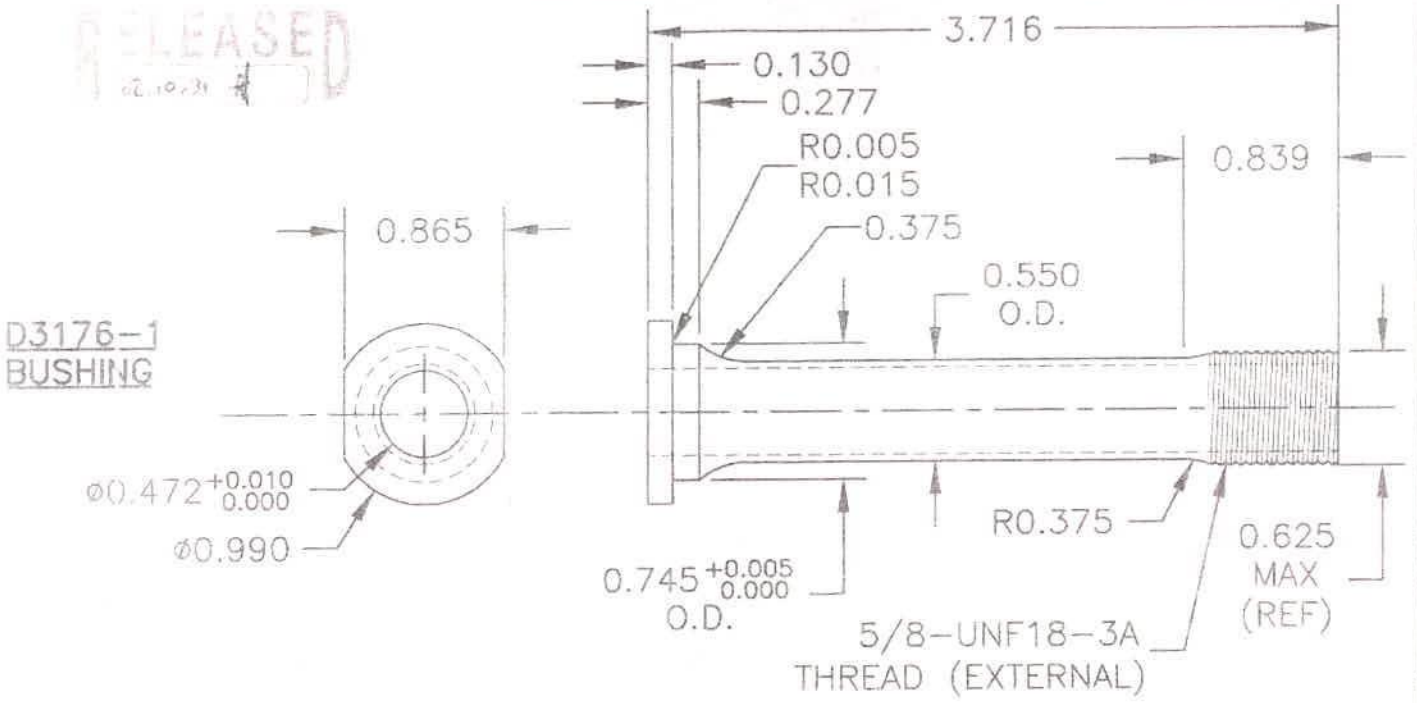
Measured by:	[signature]	Audited by:	[signature]	Prototype Approval:	N/A
Date:	07/07/12	Date:	07/07/12	Date:	N/A

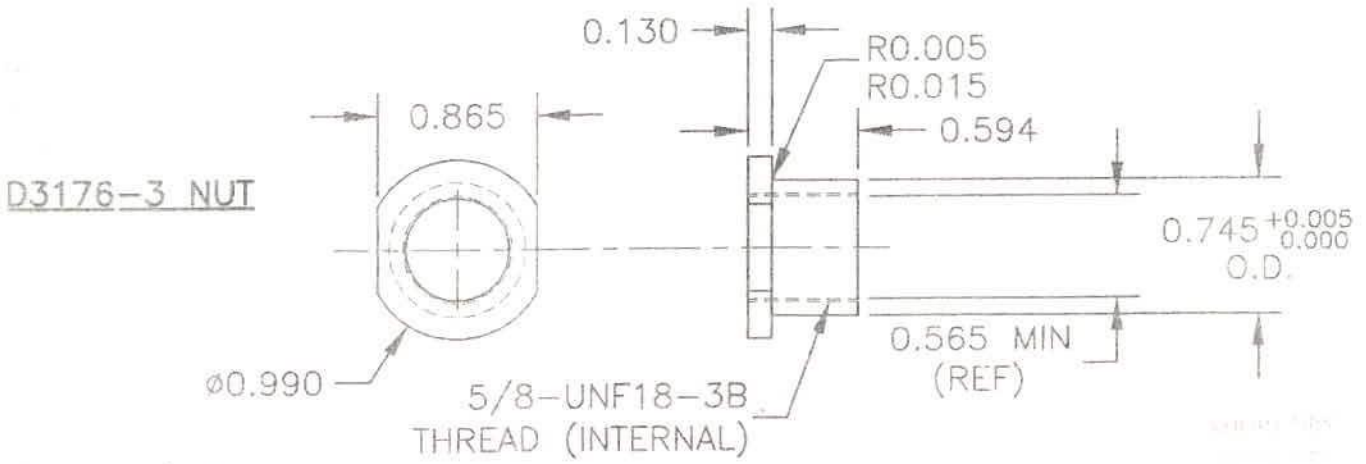
Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue	KJ/RF	
B	06.03.09	Added 5/8-UNF18-3B	KJ/JLM [signature]	[signature]

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3176	REV. A SHEET 1 OF 1
DATE 02.10.28		TITLE BUSHING / NUT	SCALE 1:1
A	02.10.28	NEW ISSUE	

DA COPY ISSUED

RELEASED 02.10.28





D3176-1/-3

1) MATERIAL: AISI 303 S.S. (REF DART SPEC. M303R1.000)
2) THREADS PER MIL-S-7742
3) BREAK ALL SHARP EDGES 0.005 TO 0.015
4) FINISH: NONE
5) ALL DIMENSIONS ARE IN INCHES
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7) D3176-1/-3 ARE MATING PARTS

№ 33222

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